



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4464-041
Job Sheet 169544



Part No: D4464-041

Job Qty: 1 ea

Part Name: Fuel Tank Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/13/17

Job Tracking No:

Due Date: 1/31/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV H IPP REV:A 11.11.23 NEW ISSUE DD VERF:EC IPP REV:B 12.03.08 AS PER DWG REV.B DD VERF:EC IPP REV:C 12.04.24 ECN 12-571 DD VERF:EC IPP REV:D 13.10.30 DWG REV PE1 DD VERF:JLM IPP REV:E 14.06.13 AS PER DWG REV.E DD VERF:JLM IPP REV:F 14.07.21 AS PER DWG REV.F DD VERF:JLM IPP REV:G 15.01.15 AS PER DWG REV.G DD VERF:JLM IPP REV:H 15.03.04 AS PER DWG REV.H9 DD VERF:JLM IPP REV:I 15.06.17 AS PER DWG REV.H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/27/18	0.00	0.00	Start Up Large Fab-7		DC-2018-01-15
100	Large Fab	1 pcs		1/29/18	0.00	10.34	Large Fab 2		CPC
110	QC	1 pcs		1/29/18	0.00	0.00	QC9		14 2018-01-15
112	Small Fab	1 pcs		1/29/18	0.17	1.53	Small Fab-6		
114	QC	1 pcs		1/29/18	0.00	0.00	QC5		
120	Large Fab	1 pcs		1/30/18	0.00	10.34	Large Fab 2		CPC
123	Small Fab	1 pcs		1/30/18	0.00	1.53	Small Fab-6		
140	Large Fab	1 pcs		1/30/18	0.00	10.34	Large Fab 2		CPC
141	QC	1 pcs		1/30/18	0.00	0.00	QC9		PD 18-01-20
142	QC	1 pcs		1/30/18	0.00	0.00	QC5		PD 18-01-20
143	Outsource	1 pcs		1/30/18	0.00	0.00	Outsource2		Inst 18/01/27
145	Packaging	1 pcs		1/30/18	0.00	0.00	Packaging2		
147	QC	1 pcs		1/30/18	0.00	0.00	QC6		
150	HandFinish	1 pcs		1/30/18	0.00	1.32	HandFinish1		2018/01/29/21
160	QC	1 pcs		1/30/18	0.00	0.00	QC7-3		
164	Small Fab	1 pcs		1/30/18	0.00	1.53	Small Fab-6		DAS 38
169	QC	1 pcs		1/30/18	0.00	0.00	QC5		
170	SprayPaint	1 pcs		1/30/18	0.00	1.73	Spray Paint		1-1 28/02/03
180	QC	1 pcs		1/30/18	0.00	0.00	QC14		18-02-08
190	Small Fab	1 pcs		1/31/18	0.00	1.53	Small Fab-6		DAS 38
200	QC	1 pcs		1/31/18	0.00	0.00	QC5		
210	Packaging	1 pcs		1/31/18	0.00	0.00	Packaging3-2		FEB 06 2018
220	QC21-SA	1 Ea		1/31/18	0.00	0.00	QC21		21 FEB 06 2018

Part Op 100 - 1- Weld D4023-3 cap as per dwg D4464 2- Buff alodine on all edges welded parts.

Descriptions: 112 - 1- Wet install baffles to front and back panel using rivet and Proseal as per dwg A/R Proseal

Batch: 138708

120 - 1- Use fixture to weld D4125 bolws to D4463-13 as per dwg. 2- Tack Weld D4463-3 to side, front a back panel.

123 - Transfer drill and c/sink D4975-1 bracket to bottom bracket, wet install as per dwg Proseal 890B

Batch: 138708 Install hinge wet with proseal as per dwg A/R Proseal 890B Batch: 138708 Instal

D4000-9 grommets as per dwg, ***D4000-1 FLAT SURFACE MUST BE INSTALL UPWARDS AS PER DWG*** Install

fitting D4000-1 wet with proseal as per dwg A/R Proseal 890B Batch: 138708

000504

Plex 12/13/17 1:18 PM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																																		
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140 - Weld top D4463-1 using DT9811 and DT9810 Finish welding the rest of the tank.

143 - ISSUE P/O : _____ LPI INSPECTION

150 - 1- Alodine on tank. No alodine inside

164 - 1- Brush Proseal 890A on all internal sheet metal folds Proseal 8990A Batch: 138708 2- Assemble as per dwg and for D4577-041/-3/-5 access panels install wet with proseal 890B A/R Proseal 890B Batch: 138708

170 - ***MASK PROIOR PRIME AND PAINT AS PER DWG*** PRIME TEMPO GREY AS PER DWG AND QSI PRIMER BATCH: 138646 PAINT FLAT GREY AS PER DWG AND QSI PAINT BATCH: M136996

190 - 1- Install placards, fuel sender, tank support, fuel filler splash guard assy, fuel cap as per dwg 2- Abrade surface with red scotch brite and install cushion using contact cement A/R Contact Cement Batch: 1300L

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D3999-7 - F156521	1	5	0	0
	D4000-045 - F16555 F160585	1	0	0	0
	D4000-1 B161942-283	1	8	0	0
	D4000-5 - F158936	1	12	0	0
	D4000-9 F152269	3	12	0	0
	D4008-11 - F165235	1	3	0	0
	D4057-1 F156450	3	43	0	0
	D4125-1 - F156449	1	6	0	0
	D4125-3 - F156458	1	3	0	0
	Store D4404-5 P160607	2	4	0	0
	D4462-1 - F160608	1	1	0	0
	D4462-3 - F164455	1	3	0	0
	D4463-041 - F163300	1	2	0	0
	D4463-11 - F163009	1	5	0	0
	D4463-3 - F163531	1	3	0	0
	D4463-5 - F106751	1	2	0	0
	D4463-7 - F160612	1	3	0	0
	D4463-9 - F160614	1	1	0	0
190-Small Fab	AN3-5A F1137963-1	24	460	0	0
	AN3-7A	4	98	0	0
	AN3H5A 137321	5	42	0	0
	D3997-11	1	5	0	0
	D3997-17	1	4	0	0
	D3997-29	1	5	0	0
	D3997-43	1	0	0	0
	D3997-5	2	10	0	0
	D4008-041	1	5	0	0
	D4023-3 - F154435	1	6	0	0
	D4062-041 - F159849	1	2	0	0
	D4463-13	1	1	0	0
	D4577-041 - F161870	1	4	0	0
	D4577-1 - F162023	1	5	0	0
	D4577-3 - F161869	1	4	0	0
	D4968-1	1	3	0	0
	D4975-1 - F163687	1	4	0	0
	D5473-068 D4025-5	1	0	0	0
	MS20426AD4-4 F165445-4	4	1,912	0	0
	MS20470AD4-4 5027554	165	1,403	0	0
	MS20470AD4-6 F165445-4	8	1,386	0	0
	MS21042L3 5057841	4	4,361	0	0
	NAS1149D0332J 4012	10	4,003	0	0
	NAS1149D0363J 5015269	24	4,739	0	0
	NAS1149D03616J IX				

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632 - 5200 Email: sales@dartaero.com www.dartaerospace.com		DISPOSITION Start up Operation 01/15/18 Job No: 169544		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%; border-right: 1px solid black;">Skid-tube</td> <td style="width:10%; border-right: 1px solid black;">☐</td> <td style="width:15%; border-right: 1px solid black;">Cross tube</td> <td style="width:10%; border-right: 1px solid black;">☐</td> <td style="width:15%; border-right: 1px solid black;">Water Jet</td> <td style="width:10%; border-right: 1px solid black;">☐</td> <td style="width:15%; border-right: 1px solid black;">Engineering</td> <td style="width:10%; border-right: 1px solid black;">☐</td> </tr> <tr> <td style="border-right: 1px solid black;">Machining</td> <td style="border-right: 1px solid black;">☐</td> <td style="border-right: 1px solid black;">Small Fab</td> <td style="border-right: 1px solid black;">☐</td> <td style="border-right: 1px solid black;">Prod. Eng. Coord.</td> <td style="border-right: 1px solid black;">☐</td> <td style="border-right: 1px solid black;">Quality</td> <td style="border-right: 1px solid black;">☐</td> </tr> <tr> <td style="border-right: 1px solid black;">Thermoforming</td> <td style="border-right: 1px solid black;">☐</td> <td style="border-right: 1px solid black;">Finishing</td> <td style="border-right: 1px solid black;">☐</td> <td style="border-right: 1px solid black;">Rec/Store/Packaging</td> <td style="border-right: 1px solid black;">☐</td> <td style="border-right: 1px solid black;">Other</td> <td style="border-right: 1px solid black;">☐</td> </tr> <tr> <td style="border-right: 1px solid black;">Large Fab</td> <td style="border-right: 1px solid black;">☐</td> <td style="border-right: 1px solid black;">Composite</td> <td style="border-right: 1px solid black;">☐</td> <td style="border-right: 1px solid black;">Supplier</td> <td style="border-right: 1px solid black;">☐</td> <td style="border-right: 1px solid black;"></td> <td style="border-right: 1px solid black;">☐</td> </tr> </table>				Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Large Fab	☐	Composite	☐	Supplier	☐		☐
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038831

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO038831
PO Date: 1/22/18
Due Date: 1/25/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

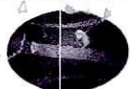
Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	167186	D4883-7	End Fitting Outsource process - NDT per QSI038 4.1 Issue P/O: _____ LPI Per ASTM 1417 LEVEL 2 Certificate of conformaty is required.	Firmed	1/25/18	10 pcs	0 pcs	10 pcs	\$55.1429/pcs	\$551.43
2	167164	D4885-3	End Fitting ISSUE P/O : _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417	Firmed	1/25/18	8 pcs	0 pcs	8 pcs	\$55.1429/pcs	\$441.14
3	169544	D4464-041	Fuel Tank Assembly ISSUE P/O : _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	1/25/18	1 pcs	0 pcs	1 pcs	\$55.1429/pcs	\$55.14
4	168063-C	D212-664-201	Aft Crosstube - High ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	1/25/18	1 pcs	0 pcs	1 pcs	\$55.1429/pcs	\$55.14
5	170235	D212-664-201	Aft Crosstube - High ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	1/25/18	1 pcs	0 pcs	1 pcs	\$55.1429/pcs	\$55.14
Grand Total:										\$1,158.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report

18/01/27 mnd

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO34719	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO038831
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON:

2 AFT CROSSTUBES, P/N# D212-664-201 , J/S# 168063-C, 170235 ✓

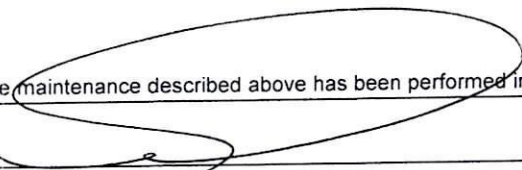
1 FUEL TANK ASSY, P/N# D4464-041 J/S# 169544 ✓

8 END FITTING, P/N# D4885-3 , J/S# 167164 ✓

10 END FITTING, P/N# D4883-7 , J/S# 167186 ✓

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13 ***NO CRACK FOUND*** PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142						JAN 23 2018	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: JAN 23 2018
Name: RAFIK MELIKIAN		



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Master Unit 000504

Tel (613) 632-5200

Containers on Master Unit 000504				
Serial No	Part No	Customer Part No	Status	Quantity
S039074	AN3-5A	AN3-5A	Allocated	4
S039080	AN3-5A	AN3-5A	Allocated	20
S039079	AN3-7A	AN3-7A	Allocated	4
S039075	AN3H5A		Allocated	5
S039061	D3997-11		Allocated	1
S039062	D3997-17		Allocated	1
S039065	D3997-29		Allocated	1
S039072	D3997-43		Allocated	1
S039060	D3997-5		Allocated	2
S039058	D4008-041		Allocated	1
S039053	D4023-3		Allocated	1
F154427	D4025-5		Allocated	1
S039052	D4062-041		Allocated	1
F160617	D4463-13		Allocated	1
F161870	D4577-041		Allocated	1
S039051	D4577-1		Allocated	1
S039050	D4577-3		Allocated	1
S039084	D4968-1		Allocated	1
S039049	D4975-1		Allocated	1
S039048	MS20426AD4-4	MS20426AD4-4	Allocated	4
S039046	MS20470AD4-4		Allocated	165
S039045	MS20470AD4-6	MS20470AD4-6	Allocated	8
S039044	MS21042L3	MS21042L3	Allocated	4
S039056	NAS1149D0316J		Allocated	1
S039042	NAS1149D0332J	NAS1149D0332J	Allocated	12
S039041	NAS1149D0363J	NAS1149D0363J	Allocated	24